

**Work Order ID 52329**

Page 1

Tuesday, September 22, 2009 3:12:17 PM

Item ID: D2731-3

Accept



Setup Start



Revision ID: B

Stop



Item Name: Mounting Lug

Start Date: 9/23/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan: *RP*

Date: 09-9-24

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
100		0.00							
	BAND SAW								
Bandsaw	Memo	0.00	<i>mh 09/10/24</i>			<i>40</i>	<i>0</i>		
Jeaspa Bandsaw	Cut D2423 Extrusion: 0.82" Long								
110		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per folio D2731-3 □ Check for crack while loading into the machine □ Tumble Deburr any rough edges after tumbling					<i>mh 8</i>	<i>09/10/24</i>		
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
	Memo	0.00							
QC									
Quality Control									
			<i>mh 2</i>	<i>09/10/24</i>					



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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



QC3- Inspect Part Finish

0.00

BK 09-10-27

(39)

0.00

QC

Memo

Quality Control

170



Identify as per dwg &amp; Stock Location: 469

0.00

0.00

Memo

Packaging

Packaging

180



QC21- Final Inspection - Work Order Release

0.00

0.00

QC

Memo

Quality Control

10-09-28

MF  
09-10-28

# Picklist Print

Page 1

Tuesday, September 22, 2009 3:12:16 PM

Work Order ID: 52329



Parent Item: D2731-3RevB



Parent Item Name: Mounting Lug

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2731-3PRevB		Purchased		No		100	Each	0.0000	40.0000			N/A.
Lug					MF 09-10-26							
D2423RevB1		Manufactured		No		110	f	684.6908	2.8758			

Lug Extrusion

<u>Warehouse</u>	<u>Loc Oty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	684.69078	
→43722	213.01468	2.8758
44529	22.39	on 09/10/24
45800	449.2861	

8

7

6

5

4

3

2

SHOP COPY 1

RETURN TO  
ENGINEERINGUNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 52329

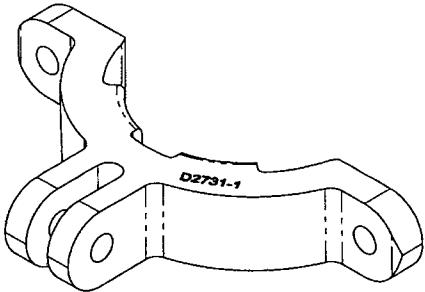
Rev B

D

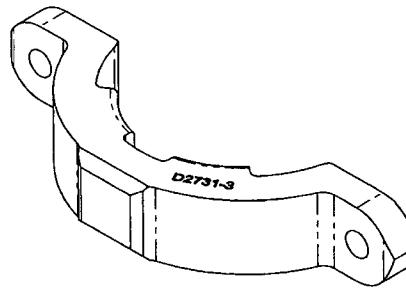
D

C

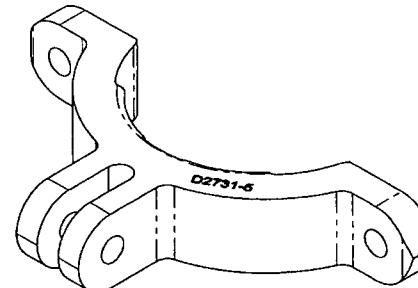
C



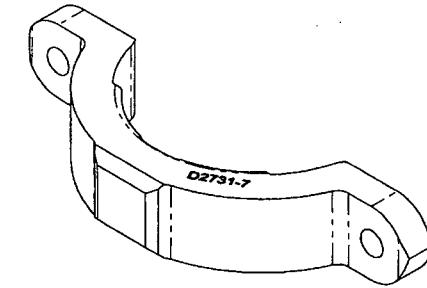
D2731-1 MOUNTING LUG



D2731-3 MOUNTING LUG



D2731-5 MOUNTING LUG



D2731-7 MOUNTING LUG

RELEASED  
*(CR/10/15/15)*

## NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF  $0.010 \pm 0.005$  IN THIS LOCATION, WITH TOOL TIP RADIUS  
OF  $0.015 \pm 0.005$ .
- 7) WEIGHT: -1: 0.17 lbs  
-3: 0.15 lbs  
-5: 0.16 lbs  
-7: 0.14 lbs

8

7

6

5

4

3

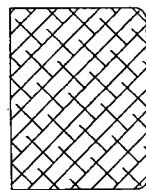
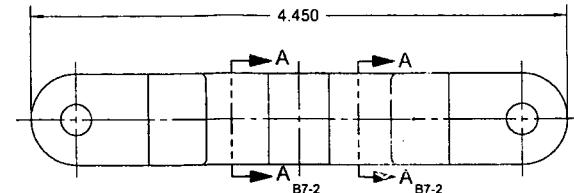
2

1

C	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A, B-B, C-C & D-D FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.19
B	REVISED DIMENSIONS	KE	99.07.06
A	NEW ISSUE	KE	98.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN DRAWN	KE AJS	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
CHECKED		DRAWING NO. D2731	REV. C SHEET 1 OF 5
MFG. APPR.		TITLE MOUNTING LUG	SCALE NTS
APPROVED M	DE APPR.	DATE 09.01.19	

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A



**C SECTION A-A D4-2**  
SCALE 2X

R0.06 MIN-R0.10 MAX  
2 PI

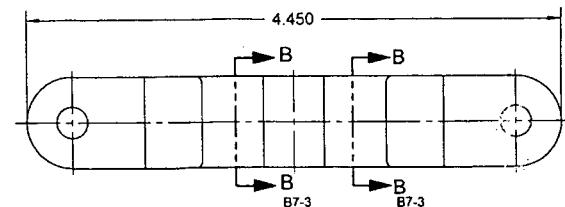
Technical drawing showing a central slot with two circular features. Dimension lines indicate a total width of 3.700, a left radius of R0.38, a left height of 0.375, a right height of 0.750, and a right diameter of Ø0.257. A centerline 'C' is labeled 'SYM ABOUT'.

### **D2731-1 MOUNTING LUG**

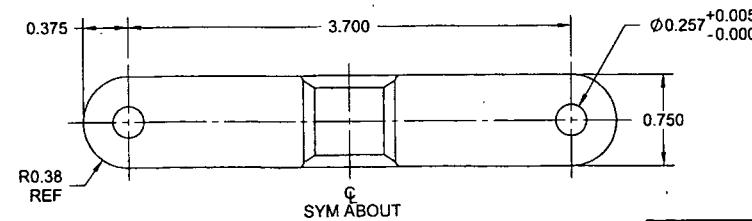
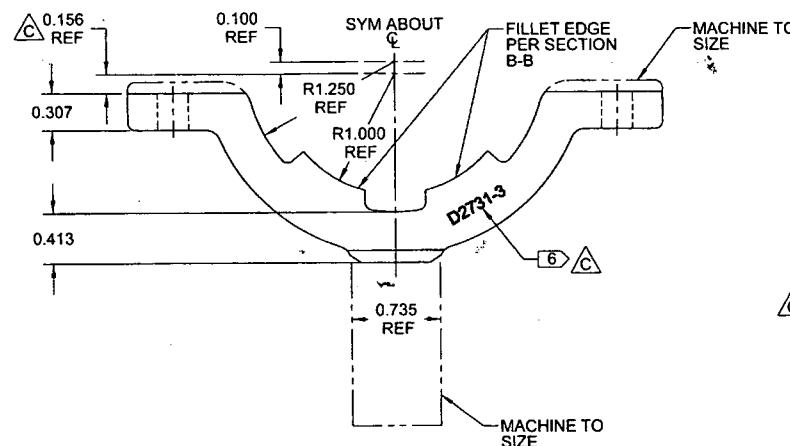
RELEASED  
09/06/25 AM

DESIGN	KE	DART AEROSPACE USA, INC.		
DRAWN	AJS	PORT HADLOCK, WA		
CHECKED		DRAWING NO.	REV. C	
MFG. APPR.	<i>Stefan</i>	D2731	SHEET 2 OF 5	
APPROVED	<i>MW</i>	TITLE	SCALE	
DE APPR.	<i>MM</i>	MOUNTING LUG	NTS	
DATE	09.01.19			

8 . . . . . 7 . . . . . 6 . . . . . 5 . . . . . 4 . . . . . 3 . . . . . 2 . . . . . 1 . . . . .



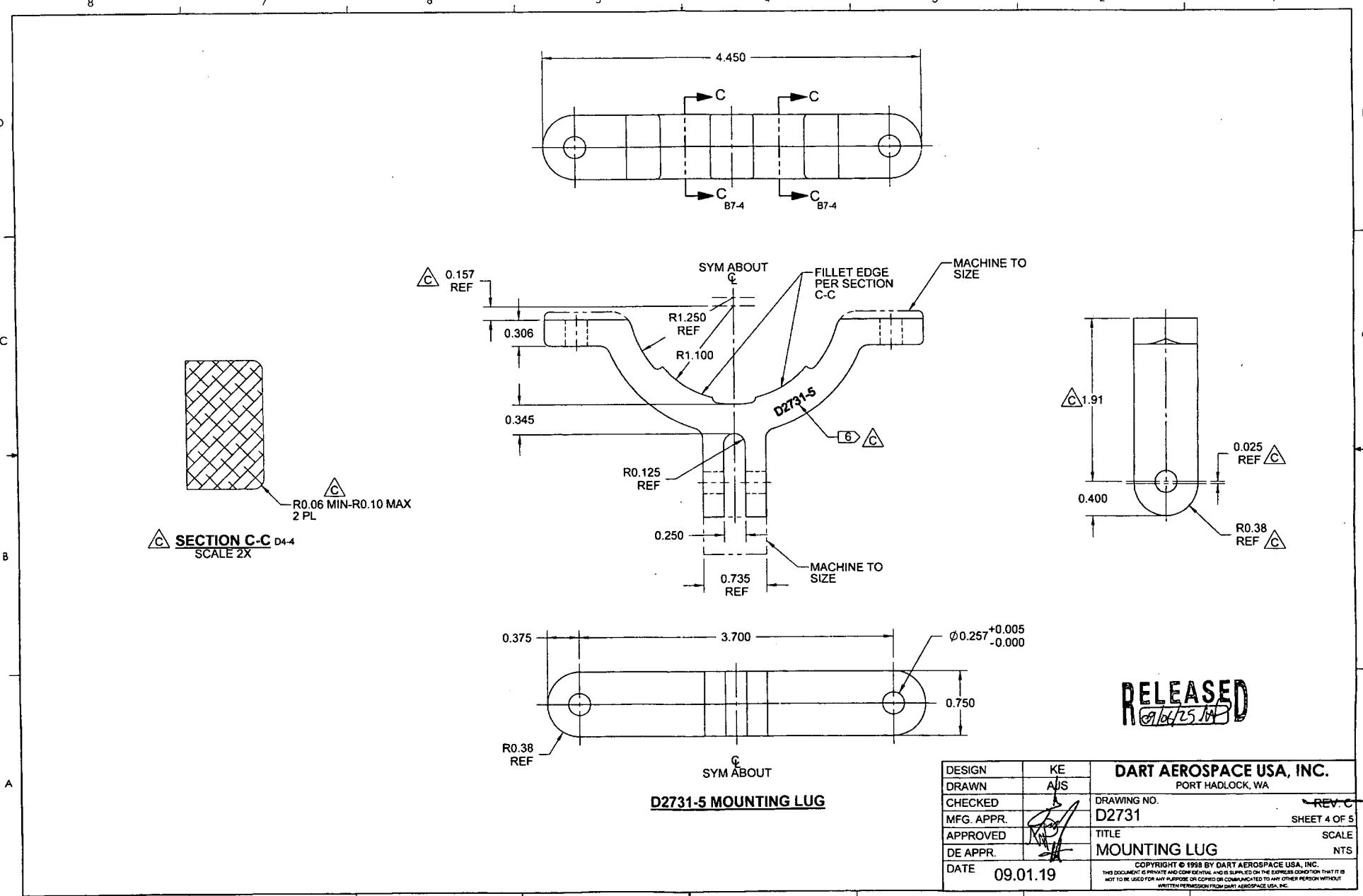
← R0.06 MIN-R0.10 MAX / C  
2 PL

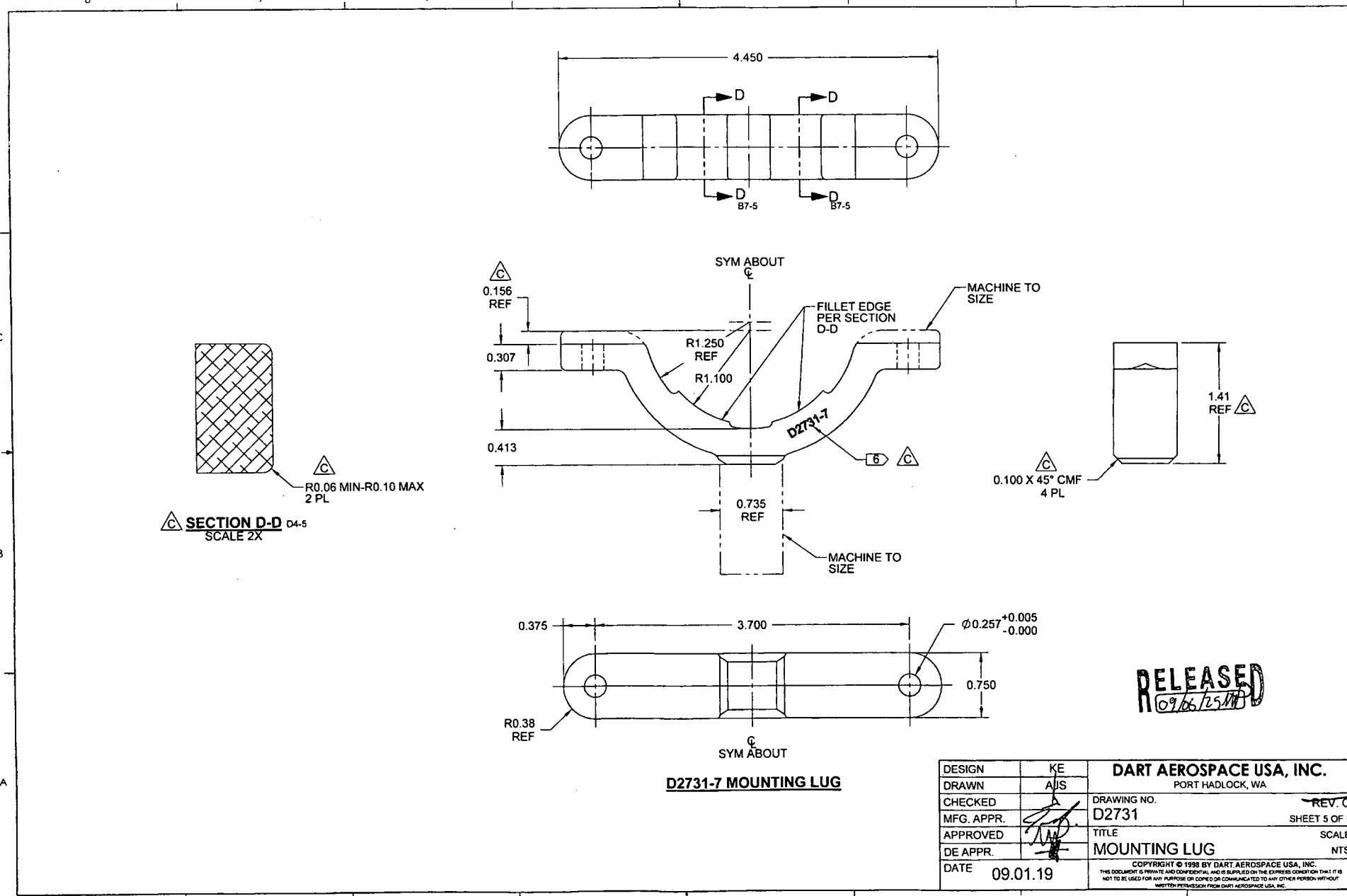


**D2731-3 MOUNTING LUG**

RELEASED  
07/06/25 MWD

DESIGN	KE	DART AEROSPACE USA, INC.		
DRAWN	AUS	PORT HADLOCK, WA		
CHECKED	<i>S</i>	DRAWING NO.	REV. C	
MFG. APPR.	<i>JH</i>	D2731	SHEET 3 OF 5	
APPROVED	<i>JW</i>	TITLE	SCALE	
DE APPR.	<del><i>JW</i></del>	Mounting Lug	NTS	
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DART AEROSPACE LTD	Work Order:	52829
Description: Lug	Part Number:	D2731-3
Inspection Dwg: D2731 <del>Rev E</del>		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## **x** First Article **□** Prototype

Measured by: <u>mnj</u>	Audited by: <u>88</u>	Prototype Approval: N/A
Date: <u>09/10/26</u>	Date: <u>09/10/27</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.04.22	New Issue	KJ/RF	PP